



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D135-1027-153
Job Sheet 190562



Part No: D135-1027-153

Job Qty: 1 pcs

Part Name: Mid Height Fwd Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Created By: Jesse White

Description: SIOP

Due Date: 3/29/19

Type: Stock

Note: D135-1027-153 REV.B IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM IPP REV:B 18.01.02 AS PER DWG
REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Handfinish - 1 - Chemical	1 pcs	3/29/19		0.00	0.17	Handfinish - 1 - 1		
							Handfinish - 1 - 2		
							Handfinish - 1 - 3		
							Handfinish - 1 - 4		
							Handfinish - 1 - 5		
							Handfinish - 1 - 6		
							Handfinish - 1 - 7		
							Handfinish - 1 - 8		
							Handfinish - 1 - 9		
							Handfinish - 1 - 10		
							Handfinish - 1 - 11		
							Handfinish - 1 - 12		
							Handfinish - 1 - 13		
							Handfinish - 1 - 14		
							Handfinish - 1 - 15		
							Handfinish - 1 - 16		
							Handfinish - 1 - 17		
							Handfinish - 1 - 18		
							Handfinish - 1 - 19		
							Handfinish - 1 - 20		
							Handfinish - 1 - 21		
							Handfinish - 1 - 22		
105	QC 7	1 pcs	3/29/19		0.00	0.00	QC 7 - 10		
							QC 7 - 13		
							QC 7 - 14		
							QC 7 - 15		
							QC 7 - 17		
							QC 7 - 18		
							QC 7 - 19		
							QC 7 - 2		

Plex 3/15/19 1:37 PM Dart.Hadley.Shannon

PTD



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S164578



Part: D135-1027-153

Job No: 190562

Serial No/Batch: S164578

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 03/21/19

DAS
10
9-89

110 Purchasing	1 pcs	3/29/19	0.00 0.00	QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				Purchasing - 1	03/21/2019 PL
				Purchasing - 2	
				Purchasing - 3	
120 Packaging 2-1 - Receive - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
130 QC 6	1 pcs	3/29/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	

132 Crosstubes - 2 - B4B	1 pcs	3/29/19	0.00 1.00	QC 6 - 68	
				QC 6 - 61	
				Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	DD/GP 19-65
135 QC 15	1 pcs	3/29/19	0.00 0.00	Crosstubes - 4 - B4B	
				QC 15 - 12	
				QC 15 - 3	
				QC 15 - 47	
				QC 15 - 49	
140 Outsource	1 pcs	3/29/19		QC 15 - 58	
				QC 15 - 9	JUN 14 2019 DAS 68
150 Packaging 2-2 - Receive - B4B	1 pcs	3/29/19	0.00 0.00	SKY002-VC	2 JUN 2019-06-14 68
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	JUN 17 2019
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
160 QC 6	1 pcs	3/29/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	JUN 17 2019 DAS 40
				QC 6 - 68	
				QC 6 - 61	8-89
170 Packaging 3-1 - Stock - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	

Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	AS 19-6-17
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B	
QC 21 - FG - 21	DAS 21 JUN 17 2019
QC 21 - FG - 70	9-89 JUN 17 2019
QC 21 - FG - 53	

180 QC 21 - FG 1 pcs 3/29/19 0.00 0.00

Part Op 100 - (Chemical Conversion Coat per QSI005 4.1) Alodine prior to sending the extrusion to an outside vendor.
Descriptions: 105 - (QC7-Inspect Chemical Conversion Coat)
110 - Issue P/O to Tube Caron: _____ Manufacture D135-1027-153 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required
120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure material release note is attached
130 - (QC6- All purchased or subcontracted products)
132 - (Crosstube Grinding Booth) REMOVE ALL MARK AS PER DWG
135 - (QC15- Crosstube Dimensional Check)
140 - ISSUE P/O: 43731 C OF C IS REQUIRED
150 - (Receive & Inspect for Damage & Mat'l Certs) C OF C IS REQUIRED
160 - (QC6- All purchased or subcontracted products)
170 - (Identify as per dwg & Stock Location: L6050)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6025-120	Crosstube Material	1 Ea (1 ea)	100-Handfinish - 1 - Chemical	S152385
D135-1027-153P	Mid Height Fwd Crosstube	1 pcs (1 ea)	120-Packaging 2-1 - Receive - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Handfinish - 1 - Chemical	D6025-120	1	54	0
120-Packaging 2-1 - Receive - B4B	D135-1027-153P	1	4	0

DAS
10
9-89

DAS
10
9-89

Part Specifications
Specifications could not be found.

Plex 3/15/19 1:37 PM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D135-1027-153
Job Sheet 190562



Part No: D135-1027-153 Job Qty: 1 ea

Part Name: Mid Height Fwd Crosstube



Part Weight: 0 lbs Status: New Priority: Medium

Job Created: 2/11/19 Job Tracking No:

Due Date: 3/29/19 Created By: Jesse White

Type: Stock Description: SIOP

Note: D135-1027-153 REV.B IPP REV:A 17.01.24 NEW ISSUE DD VERF:JLM IPP REV:B 18.01.02 AS PER DWG
REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/29/19	0.00	0.00			
100	HandFinish	1 pcs		3/29/19	0.00	0.17	HandFinish1		
105	QC	1 pcs		3/29/19	0.00	0.00	QC7-5		
110	Purchasing	1 pcs		3/29/19	0.00	0.00	Purchasing		
120	Packaging	1 pcs		3/29/19	0.00	0.00	Packaging2		
130	QC	1 pcs		3/29/19	0.00	0.00	QC6		
132	Crosstubes	1 pcs		3/29/19	0.00	1.00	Crosstube Grinding Booth		
135	QC	1 pcs		3/29/19	0.00	0.00	QC15		
140	Outsource	1 pcs		3/29/19			SKY002-VC	2	
150	Packaging	1 pcs		3/29/19	0.00	0.00	Packaging2		
160	QC	1 pcs		3/29/19	0.00	0.00	QC6		
170	Packaging	1 pcs		3/29/19	0.00	0.00	Packaging3-1		
180	QC21-FG	1 Ea		3/29/19	0.00	0.00	QC21		

Part Op 100 - Alodine prior to sending the extrusion to an outside vendor.

Descriptions: 110 - Issue P/O to Tube Caron: 042567 Manufacture D135-1027-153 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required
120 - Ensure material release note is attached
132 - REMOVE ALL MARK AS PER DWG
140 - ISSUE P/O: C OF C IS REQUIRED
150 - C OF C IS REQUIRED

dh

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6025-120	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	
D135-1027-153P	Mid Height Fwd Crosstube	1 pcs (1 ea)	120-Packaging	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6025-120	1	54	0
120-Packaging	D135-1027-153P	1	4	0
Part Specifications				
Specifications could not be found.				

Plex 2/11/19 12:49 PM dart.white.jesse



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO042567



Supplier: TUB001-VC Tube Caron Inc. 99 Louis-Joseph-Doucet Street Lanoraie QC JOK 1EO Canada Phone: 450-887-2766 Fax: 450-887-2897	PO No: PO042567 PO Date: 2/11/19 Due Date: 3/22/19 Purchase Order Revision: Revision Date: Ship-To Contact: Phone: Via: Ground Pymt Terms: Net 30 Freight Terms: Special Comments:
Ship To: 1270 Aberdeen Street Hawkesbury ON K6A 1K7 Canada Phone: 613-632-5200	

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
190567		D135-1027-253	Mid Height Aft Crosstube (Purchasing) Issue P/O to Tube Caron: Manufacture D135-1027-253 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6027-115** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00

Line Item Note: REV C											
190568	1 X	MAR 2 1 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
190569	1 X	MAR 2 1 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191900	1 X	MAR 2 1 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
191901	1 X	MAR 2 1 2019	Firmed	-		3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							5	0	5		\$1,500.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
12	190489	D135-1027-251	Std Height Aft Crosstube Issue P/O to Tube Caron: Manufacture D135-1027-251 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6026-110** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Line Item Note REV D											
	190571	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	190572	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191903	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191905	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191907	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							6	0	6		\$1,800.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO042567



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190560	D135-1027-153	Mid Height Fwd Crosstube Issue P/O to Tube Caron: Manufacture D135-1027-153 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Line Item Note: REV B											
190562	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00	
190564	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00	
191909	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00	
191910	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00	
Sub Total:							5	0	5		\$1,500.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042567



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	190575	D135-1027-151	Std Height Fwd Crosstube Purchasing - Issue P/O to Tube Caron: Manufacture D135-1027-151 as per dwg (Bend, Remove excess material after bending) **Ship extrusion D6025-120** ***AS PER DWG NOTE 10, EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** Material release note is required	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Line Item Note: REV D											
	190576	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
	191908	1 X	MAR 21 2019	Firmed	-	3/22/19	1 pcs	0 pcs	1 pcs	\$300.00/pcs	\$300.00
Sub Total:							3	0	3		\$900.00

Grand Total: \$5,700.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/21/19 12:52 PM dart.Lussier.Patrick



SHIPPING BILL

BOL 14944

13/03/2019

Tube Caron Inc. 99 Louis-Joseph-Doucet Lanoraie, QC, Canada J0K 1E0 Phone: 450-887-2766 Fax: 450-887-2897	Ship To: Dart Aerospace Ltd 1270 Aberdeen Street Hawkesbury, ON, Canada K6A 1K7 Phone : 613-632-1053 Fax : 613-632-4443
Sold To: Dart Aerospace Ltd 1270 Aberdeen Street Hawkesbury, ON, Canada K6A 1K7 Phone : 613-632-5200 Fax : 613-632-4443	Third Party Billing:

Ln	Item	Qty	Po	Job	Weight	UOM
1	PALETTE	1			20.00	Pounds
	D135-1027-151 REV D	1	PO042567	J21867-11	13.36	Pounds
	D135-1027-151 REV D	1	PO042567	J21867-12	13.36	Pounds
	D135-1027-151 REV D	1	PO042567	J21867-16	13.36	Pounds
	D135-1027-153 REV B	1	PO042567	J21867-10	14.57	Pounds
	D135-1027-153 REV B	2	PO042567	J21867-15	29.14	Pounds
	D135-1027-153 REV B	1	PO042567	J21867-8	14.57	Pounds
	D135-1027-153 REV B	1	PO042567	J21867-9	14.57	Pounds
	D135-1027-251 REV D	1	PO042567	J21867-5	16.21	Pounds
	D135-1027-251 REV D	1	PO042567	J21867-6	16.21	Pounds
2	PALETTE	1			20.00	Pounds
	D135-1027-251 REV D	3	PO042567	J21867-14	48.64	Pounds
	D135-1027-251 REV D	1	PO042567	J21867-7	16.21	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-1	19.81	Pounds
	D135-1027-253 REV C	2	PO042567	J21867-13	39.62	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-2	19.81	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-3	19.81	Pounds
	D135-1027-253 REV C	1	PO042567	J21867-4	19.81	Pounds

Carrier:	Journey Freight	Fob:	Fob Lanoraie
Phone:	1-888-633-1252 #3221	Freight Charges:	Collect
Way Bill:			

Total Of Packages :	2 PALETTES	Total Weight:	369.06 #
Carrier : Journey Freight	96 X 32 X 36	Shipper : Tube Caron Inc.	
	96 X 32 X 36		

Declared Value : (No Additional Insurance Required)

Not Applicable For Insurance Purposes

14-03-2019

CERTIFICATE OF CONFORMANCE

CUSTOMER : Dart Aerospace
DATE : March 21, 2019
P.O.# PO042567

I certify that the following parts were manufactured to the specifications stated on the drawings listed below.

Note: Material for manufacturing of parts is provided by Dart Aerospace.

PART NO.	QTY.	DRAWING NO. / REV.
D135-1027-253 ✓ MID HEIGHT AFT XTUBE	6 ✓	D135-1027-253 / REV.C
D135-1027-153 ✓ MID HEIGHT FWD XTUBE	5 ✓ <i>DD 19-03-27</i>	D135-1027-153 / REV.B
D135-1027-151 ✓ STD HEIGHT FWD XTUBE	3 ✓	D135-1027-151 / REV.D
D135-1027-251 ✓ STD HEIGHT AFT XTUBE	6 ✓	D135-1027-153 / REV.D

Sincerely,

Kevin Gadoury

Kevin Gadoury

smo 19jun 2019

Entered: _____ Date: _____
NCR No. 19-7200

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: 190562		DISPOSITION		DEPARTMENT/PROCESS				MRB (QSI042)	
Part No. D135-1627-153		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube Machining Large Fab ☐		Cross tube Small Fab Finishing ☒		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: 16/3/26	Sequence #: 130	QTY Affected: 1		Disposition ①		Completed By: WSP 12 of 16/3/26		Lead hand / Supervisor: 4/14/26	
Description Work Order Deviation								QC / QA Coordinator: 19-03-27	
Tub is bent high by cur + 6.18 cur nominal		Acceptable						19-03-27	
Root Cause		FAULT CATEGORY							
Operator ☒ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details:									

DART AEROSPACE LTD	Work Order:	190562
Description: MID HEIGHT FWD CROSSTUBE	Part Number:	D135-1027-153
Inspection Dwg: D135-1027-153 Rev: B		Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.550" TYP	+/-0.005"					
13.63" TYP	+/-0.030"					
2.14" REF	+/-0.030"					
2.75" TYP	+/-0.030"					
Ø.194" THUR 2PL	+0.006" -0.001"					
17.0" 2PL	+/-0.100"					
Ø.313" THUR 2PL	+0.006" -0.001"					
Ø.472" THUR 4PL	+0.006" -0.001"					

WALL THICKNESS MEASUREMENTS

LOCATION FROM CL	DWG DIM	R1	R2	R3	R4				
CL	0.134"								
21"	0.134"								
21"	0.134"								
CENTER OF BEND	0.134"								
CENTER OF BEND	0.134"								

OUTSIDE DIAMETER MEASUREMENTS

Location	DWG DIM	M1	M2				
CL	3.543"						
CENTER OF BEND	3.543"						
CENTER OF BEND	3.543"						

Crushing

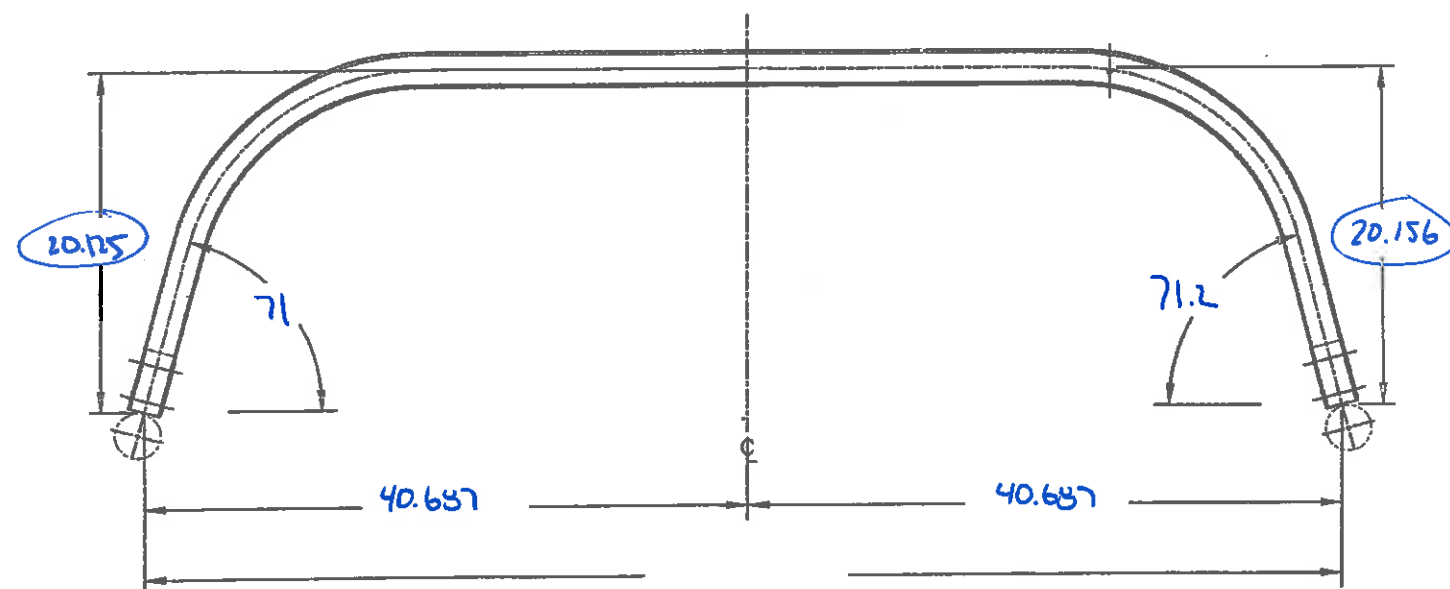
	Side A	Side B
MAX 2%	45%	31%

TWIST

	SIDE A	SIDE B
MAX 0.25"		

DART AEROSPACE LTD		Work Order:	190562
Description: MID HEIGHT FWD CROSSTUBE		Part Number:	D135-1027-153
Inspection Dwg: D135-1027-153 Rev: B		Page 2 of 2	

Required Dimension	Min	Max
Height	19.85"	20.11"
1/2 Span	40.60"	40.86"
Angle	70°	72°
Total Span	81.20"	81.72"
Bending Passes		
Crushing	0%	2%

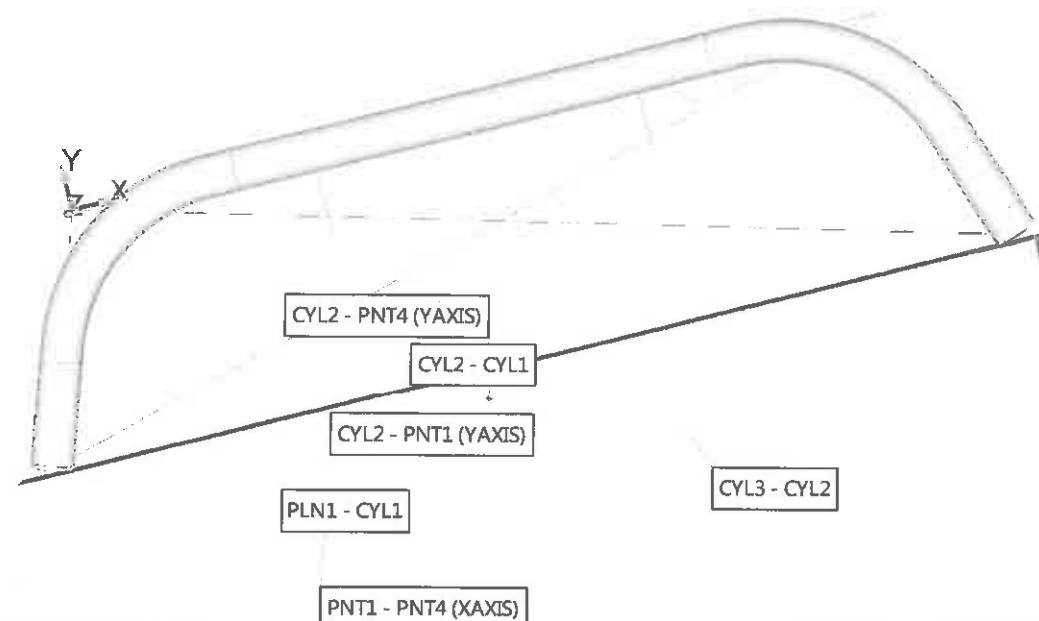


Acceptable
9/11/16

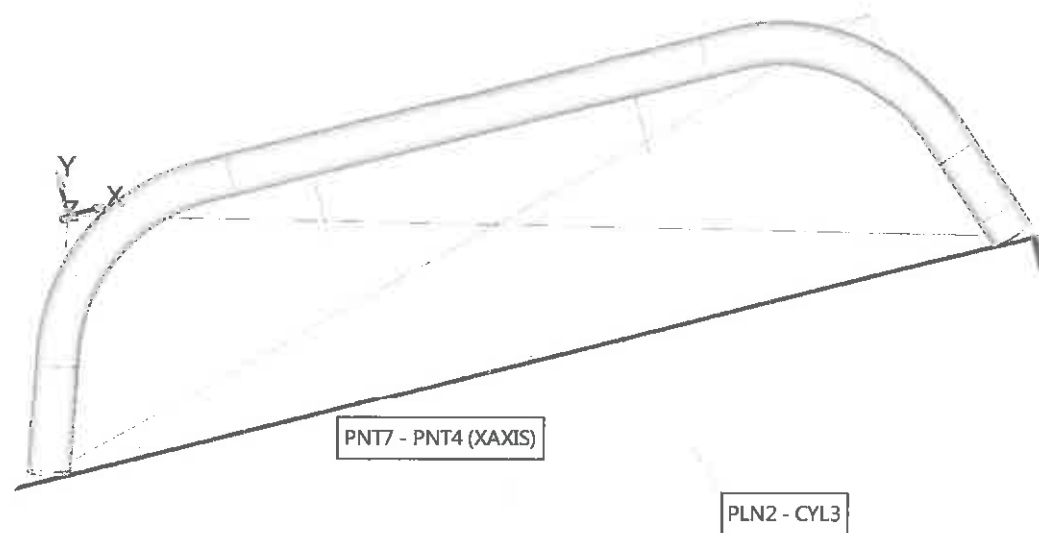
Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	

Engineering Approval: (If necessary)		Date:	
---	--	-------	--

Rev	Date	Change	Revised by	Approved
A	18/01/16	New Issue	ED	



po-admis		PART NAME : D135-1027-153_Pilage+Coupe				mars 09, 2019		13:07	
		REV NUMBER : Rev.B		SER NUMBER : 3164578				STATS COUNT : 1	
∠	DEG	ANGL1 - CYL2 TO CYL1							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
A	71.0000	0.5000	0.5000	71.1076	0.1076	0.0000			
∠	DEG	ANGL2 - CYL3 TO CYL2							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
A	71.0000	0.5000	0.5000	71.1854	0.1854	0.0000			
↔	IN	DIST1 - PNT1 TO PNT4 (XAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	81.4700	0.2500	0.2500	81.4529	-0.0171	0.0000			
↔	IN	DIST2 - CYL2 TO PNT1 (YAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	19.9800	0.1300	0.1300	20.0628	0.0828	0.0000			
↔	IN	DIST3 - CYL2 TO PNT4 (YAXIS)							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
M	19.9800	0.1300	0.1300	20.0902	0.1102	0.0000			
∠	DEG	ANGL3 - PLN1 TO CYL1							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL			
A	90.0000	0.5000	0.5000	89.7459	-0.2541	0.0000			



		DEG	PNT1 - PNT7 (XAXIS)				
			ANGL5 - PLN2 TO CYL3				
AX		NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
A		-90.0000	0.5000	0.5000	-89.8655	0.1345	0.0000
		IN	DIST4 - PNT1 TO PNT7 (XAXIS)				
AX		NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M		40.7350	0.1300	0.1300	40.7265	-0.0085	0.0000
		IN	DIST5 - PNT7 TO PNT4 (XAXIS)				
AX		NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M		40.7350	0.1300	0.1300	40.7265	-0.0085	0.0000



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043731



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043731
PO Date: 6/14/19
Due Date: 6/18/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191909	D135-1027-153	ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	190564		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	190580		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	191910		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	190562		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
Sub Total:							5	0	5		\$737.50

DAS
40
9-89

2	196120	D407-667-105	Fwd Crosstube - High 407 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** OUTSIDE SERVICE -CROSSTUBES Liquid Penetrant Inspection as per QSI 038 Or Level 2 Attach copy of NDT results to work order	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	192352		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	192353		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
	192354		JUN 14 2019	Firmed	-	6/18/19	1 pcs	0 pcs	1 pcs	\$147.50/pcs	\$147.50
Sub Total:							4	0	4		\$590.00

Plex 6/14/19 3:45 PM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB043731



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	192615	D3011-1	Rappel Slide Bar : Various STC's (Outsource process - NDT per QSI038 4.1)1- LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG D3011 2- Certificate of conformity is required	Firmed	-	6/18/19	5 pcs	0 pcs	5 pcs	\$29.50/pcs	\$147.50
Grand Total:											\$1,475.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

[Handwritten signature]

Plex 6/14/19 3:45 PM Dart.Guerin.Kimberley

		Work Order Traveler Sky Service F.B.O. Inc.	
10105 Ryan Avenue, Dorval, Quebec, H9P 1A2		TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385	
WO #: MWO40756	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB043731
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

- ✓ 5 RAPPEL SLIDE BARS , P/N# D3014-1 , J/S# 192615
- ✓ 4 FWD CROSSTUBES , P/N# D407-667-105 , J/S# 196120 , 192352 , 192353 , 192354
- ✓ 5 MID HEIGHT FWD CROSSTUBES , P/N# D135-1027-153 , J/S# 191909 , 190564 , 190560 , 191910 , 190562

DAS
40
9-89

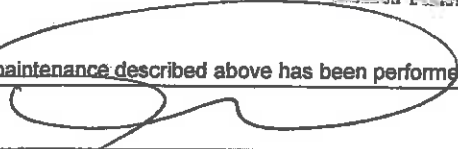
Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						JUN 14 2019	
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

RECEIVED

JUN 14 2019

DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN			JUN 14 2019